Work Order l	D 511	17									100	Page 1
Revision ID: D2 Item Name: Spa	cer 4/09	Start Qty: 20.00 Req'd Qty: 20.00		Accept	Cust Item II	 D:			Setup	Start Stop		
		: MF				te:	-	1	Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr		ion Nbr	·	Kuli Huuts	- Tumber		Cour					
100 Hardinge Hardinge CNC Lathe Sm		Hardinge CNC LATHE S Memo 1-Machine a	SMALL s per Folio FA438 and I	0.00 0.00 Dwg D2617[12-Deburr	3/08/17			21	Ø	>		
110 QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00	16થા			21	Ļ	<u></u>		
120 QC		QC8- Inspect parts - seco	and check	0.00 CM	0 4/08/11			21	· 	8_		

Memo

Quality Control

Dart Aerospace Lt

	oopaoo	- No. 1 (4)								
W/O:			WO	RK ORDER CHAI	NGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					•	
Part No		PAR #:								
Resolution:			Disposition);	QA					
NCR:			WORK ORDE	R NON-CONFOR	MANCE	(NCR				
DATE STEP		Description of NC	Description of NC Corrective Action				Verific	Verification App		Approval
	O'L'	Section A	Initial Chief Eng	Action Descriptio	on	Sign & Date	Secti		Chief Eng	QC Inspector
						·				
				A						

NOTE: Date & initial all entries

August 4, 2009 11:04:46 AM

Item ID:

D2617-5

Revision ID:

D2 Spacer

Item Name:

8/14/09

Start Oty: 20.00



Accept



Setup Start



Stop

Start Date: Required Date: 8/21/09

Reg'd Oty: 20.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Date:

Run

Start

Stop

Reject

Qty



Sequence ID/ Work Center ID

130

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ Run Hours

0.00

0.00

Draw

Number

Qty

Accept

Number Stamp

Insp.

Reject

140

OC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

09-0811



150

Packaging Packaging

Identify as per dwg & Stock Location



0.00





Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	•	PAR #:	Fault Cated	jory:	NCR: Ye	es No	DQ/	A :	_ Date: _					
	Re	solution:	Disposition):	_ QA: N/C	Clos	ed:		Date:					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)			44					
DATE	STEP	Description of NC	Corrective Action Section B				Verific			Approval				
		Section A	Initial Chief Eng	Action Description Chief Eng	tion Sign & Date			Section C Chief E		QC Inspector				

NOTE: Date & initial all entries

Work Order ID 51117

August 4, 2009 11:04:46 AM



Page 3

Item ID:

Revision ID:

D2617-5

D2

Item Name: Spacer

Start Date:

8/14/09

Required Date: 8/21/09

Start Qty: 20.00 Req'd Qty: 20.00



Accept



Setup Start

Stop

Cust Item ID: **Customer:**

Draw

Number

Reference:

Approvals:

Process Plan:

Memo

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Date:

Run

Reject

Qty

Reject

Stop

Number Stamp

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

0.00

Accept

Qty

Start

Insp.

MF 09-08-11

Dart Aerospac	e Ltd
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W/O:			WORK ORDER CHANGES										
DATE	STEP	PR	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							·		•				
					1								
						į							
Part No		PAR #:											
	Re	esolution:	Disposition	:	QA: N/0	Clos	ed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)							
DATE	STEP	Description of NC	Corrective Action Section				Verific	ation	Approval App	Approval			
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sig	gn & ate	Section		Chief Eng	QC Inspector			
								i					
								:					
<u> </u>							-,						
			·										
	, 1		1 1		1	J							

NOTE: Date & initial all entries

August 4, 2009 11:04:45 AM

Work Order ID: 51117

Parent Item: D2617-5RevD2

Parent Item Name: Spacer

arent tem Name. Spa

Comments:



Start Date: 8/14/09

Required Date: 8/21/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	182.2100	0.4105			

6061-T6 RD Tube .500 x.058W

Warehouse	Loc Qty	Loc Code		
Location				
Main Warehouse		•		
MAT	182.21			
110335	0.6			
111757	181.61	·	1 Lex.t	IN OSIES

DART AEROSPACE LTD	Work Order:	51117
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article	Prototype

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+0.000/-0.010	.219				
+/-0.010	DOZ,				
		_			
		- "			
	-				
	+0.000/-0.010	+0.000/-0.010 . 2/9	Tolerance Dimension Accept	Tolerance Dimension Accept Reject	Tolerance Dimension Accept Reject Inspection +0.000/-0.010 2/9 +/-0.010 CSOO SOO SOO SOO SOO SOO SOO SOO SOO SO

Measured by: 2 V	Audited by:	Prototype Approval:	N/A
Date: 05/08/1/	Date: 09/08/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.09	New Issue	KJ/JLM	
В	06.03.08	Dwg Rev change	KJ/JLM 1,A	
С	08.01.16	Tolerance revised for 0.500 dimension	KJ/EC/DD	



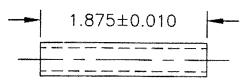


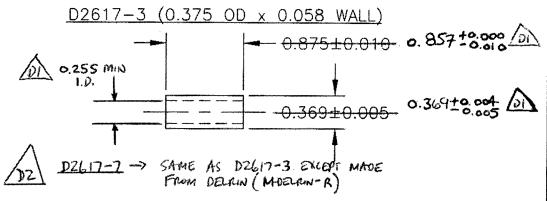
DESIG	BW	DRAWN BY		AEROSPACE LTD WKESBURY, ONTARIO, CANADA
CHECH	(ED #	APPROVED	DRAWING NO.	REV. D
	91	9	D2617	SHEET 1 OF 1
DATE			TITLE	SCALE
01.07.04		BUSHING	1:1	
Α		96.10.08	NEW ISSUE	

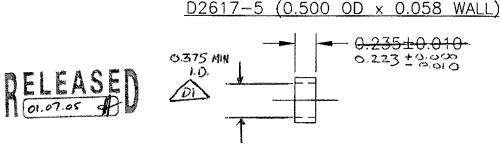
DZ 04.04.10 #112 ADD D2617-7

A	96.10.08	NEW ISSUE
В	97.05.08	.875 WAS 1.125
С	97.06.04	0.369 DIA WAS 0.375
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
DI	4-1 04,57.12	CORRECT TOLERANCE (NCR 779)

D2617-1 (0.375 OD x 0.058 WALL)







NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
 - OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

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